	Work Order ID 62459  Thursday, September 30, 2010 12:42:56 PM										Page 1
Revision ID: Item Name:	D3536-15  Gasket  D/30/2010  10/8/2010	Start Qty: 8.00 Req'd Qty: 8.00	o	Accept	Cust Item Customer:			s s	Setup Star Stop		
	Process Pla	in:	Date: 10930	Tooling: SPC (Y/N):		ate:		F	Run Star Stoj		B##
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr						2.7	20	114111001	Stamp
D3536	Rev	A									
Waterjet FLOW CNC Waterjet	·3"		s per Dwg D3536 □Dwg Rev if necessary	0.00 0.00 □Prog Rev:	<b>∆</b> □2-			<u>B</u> u	D-10-H	0	
QC Quality Control		QC2- Inspect parts o	off machine FAI/FAIB	0.00				IB.(	0-10-4		-
120 QC Quality Control		QC8- Inspect parts -	second check	رج/ر	عداد			(UL)			

		W	ORK ORDER CH	ANGES						
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### Work Order ID 62459

Thursday, September 30, 2010 12:42:56 PM



Page 2

Item ID:

D3536-15

Accept



Setup Start

Stop



**Revision ID:** 

**Start Date:** 

Required Date: 10/8/2010

**Item Name:** 

Gasket

9/30/2010

Start Qty: 8.00

Req'd Qty: 8.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Tooling:

SPC (Y/N):

Set Up/

**Run Hours** 

Date:\_\_ Date:

Run Start



Stop

Sequence ID/

Work Center ID

130

Packaging

Packaging

Operation Description

QC:

Identify as per dwg & Stock Location:

Memo

Date:\_\_\_\_\_

0.00

0.00

**Tool ID** 

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

W/O:			WO	RK ORDER CHANG	ES								
DATE	STEP	PR	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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V-101													
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## **Picklist Print**

Thursday, September 30, 2010 12:43:01 PM

Work Order ID: 62459

Parent Item:

D3536-15

Parent Item Name: Gasket



**Start Date:** 9/30/2010

Required Date: 10/8/2010

Page 1

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP Rev:A

New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	415.0353	0.9848	8.293053	10.9	7	
	NYA									1BI	0-10-4		•

**NEOPRENE SHEET 0.063** 

<b>Location</b>	Loc Oty	Loc Code		~
MAT	309.7822			(ii)
114691	105.9602		<del></del>	
115500	203.822		115500	
MAT052	105.2531			
114176	105.2531			

		<del></del>							
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DART AEROSPACE LTD	Work Order:	42459		
Description: Gasket	Part Number:	D3536-15		
Inspection Dwg: D3536 Rev: A		Page 1 of 1		

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
39.15	+/-0.030	39,15	u		TROL	
35.65	+/-0.030	35.65	~		7	
33.65	+/-0.030	33.65	٦		7	_
30.15	+/-0.030	30,15	V		7	
24.90	+/-0.030	24.96	y		7	
19.65	+/-0.030	14.65	0		7	
14.40	+/-0.030	(4,40	7		7	
9.15	+/-0.030	9.15	ರ		7	
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1.89	+/-0.030	1.890	¥		V	
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Measured by:	(B)	Audited by:	8	Prototype Approval:	N/A
Date:	10-10-4	Date:	10 100	Date:	N/A

Rev	Date	Change	Revised by Approved
Α	07.03.14	New Issue	KJ/JLM 🖟

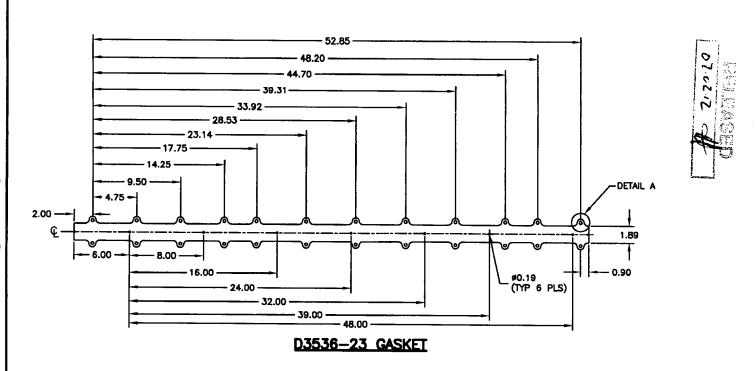
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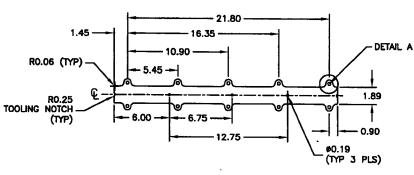
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 7	¥	D3536		SHEET	SHEET 3 OF 6
DATE		TIME			SCALE
06.10.25		GASKET			1:10



- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ©
  4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

  OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
  6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-25 GASKET

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**PURPOSE** 

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DETAIL A

13.50 #0.19 (TYP 3 PLS)

D3536-33 GASKET

22.50 19.00 2.00 -6.00 --**Q**-1.89 DETAIL A 6.00 #0.19 (TYP 3 PLS)

D3536-31 GASKET

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**PURPOSE** 

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- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

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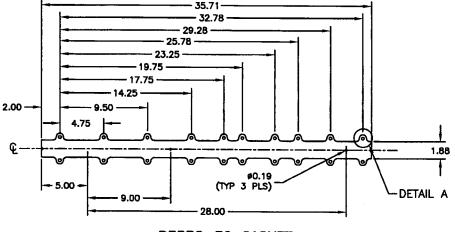
D3536-37 GASKET

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- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ©
  4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
  6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



DETAIL A

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**D3536-39 GASKET** 

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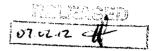
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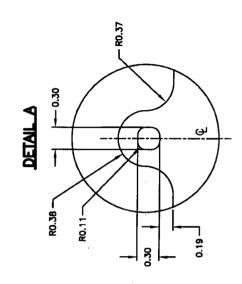
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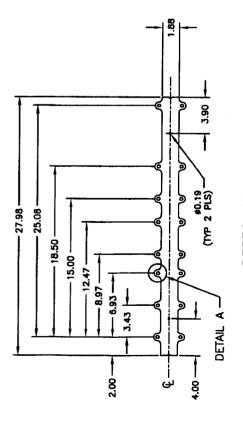


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1) MATERIAL. BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEOBO-S.063) 2) FINISH: NONE
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